



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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RB T102103
Job Sheet 186072



Part No: RB T102103

Job Qty: 1 ea

Part Name: Dehydrator Tail Rotor



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/9/18

Job Tracking No:

Due Date: 11/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP Rev A 17.10.25 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/12/18	11/12/18	0.00	0.00	Start Up Small Fab-4		MCC
110	Small Fab	1 pcs	11/12/18	11/12/18	0.00	0.33	Small Fab-3		MCC DAS
120	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC5		NOV 13 2018 68
130	Packaging	1 pcs	11/12/18	11/12/18	0.00	0.00	Packaging3-1		9-89
140	QC21-FG	1 Ea	11/12/18	11/12/18	0.00	0.00	QC21		NOV 13 2018

Part Op 110 - Assemble as per DWG. Sheet 1 ****MS27215-2 Plug Dehydrator must be Blue**** **Immediately vacuum seal RB
Descriptions: T102103 after assy***

GA150

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MS27215-2	18 mm Dehydrator Plug Alternate p/n AN814-20D	1 Ea (1 ea)	90-Start up Operation	507253
MS29561-210	Packing / Oring	1 Ea (1 ea)	90-Start up Operation	5001637
RB T102103-3	Adapter	1 Ea (1 ea)	90-Start up Operation	5033370
RB T102103-5	Retainer	1 Ea (1 ea)	90-Start up Operation	5032334
RB T102103-7	Pin	1 Ea (1 ea)	90-Start up Operation	5090978

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MS27215-2	1	10	0
	MS29561-210	1	106	0
	RB T102103-3	1	5	0
	RB T102103-5	1	5	0
	RB T102103-7	1	4	0



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Container No: S127040



Part: RB T102103

Job No: 186072

Serial No/Batch: S127040

Revision: C

Inspector:

Exp Date:

Instructions:

Date: 11/12/18

ns

be found.

Plex 11/9/18 11:36 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

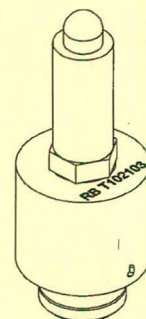
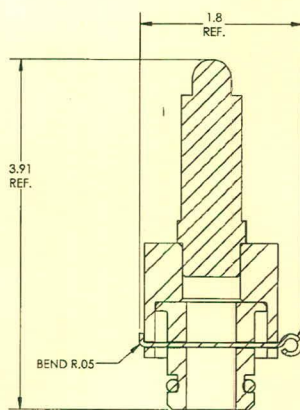
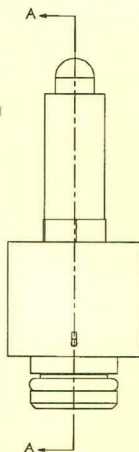
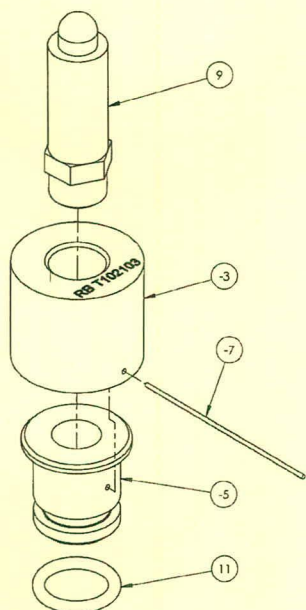
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					

ITEM #	QTY	PART #	TITLE	PG
-3	1	RB T102103-3	ADAPTER	2
-5	1	RB T102103-5	RETAINER	3
-7	1	RB T102103-7	PIN .050" OD. x 2-1/2" L.G.	4
9	1	MS27215-2	PLUG DEHYDRATOR	-
11	1	MS29561-210	O-RING 1.912" OD x 0.135" THK	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-	REDRAWN FROM TATTERED ORIGINAL DRAWING	-	11/1/2012	RJC	SE
A	-3 CHD NOTE WAS FINE DIAMOND OR STRAIGHT KNURL THIS SURFACE IS MEDIUM DIAMOND OR STRAIGHT KNURL THIS SURFACE	-	3/11/2014	DPD	GE
1	-3 ADDED BOTH SIDES TO CHAMFER	15-0156	7/1/2015	SM	JAG
C	ADD SHEET 4 FOR -7. TEMPLATE UPDATED. REMOVE GD&T COCENTRICITY TOLERANCE ON -5. REMOVE LIMIT TOLERANCE FOR 0.064/0.061" HOLE ON -5. ADD 2 PL. ON RADIUS .0157/.005" ON -3 & -5	17-709	17.10.16	VM	WM



SECTION A-A

- NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) SPEC: N/A
 5) BREAK ALL SHARP EDGES: N/A
 6) IDENTIFICATION: N/A

RB T102103 DEHYDRATOR TAIL ROTOR

DART AEROSPACE Industry Group, Canada	
TITLE: DEHYDRATOR TAIL ROTOR PART NO: RB T102103	
DESIGN BY: VM 10/10/2017 DRAWN BY: VM 10/28/2017 CHECKED: SAC 10/27/2017 DES. APPR: DP 10/30/2017 APPROVED: M/VM 10/31/2017 DATE: 10/28/2017	XXX 3 200 FRACTIONS & 1/8 XX 1/16 ANGLES & 1/2 X 1/32 SURFACES & 1/4 1- DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED 2- DIMENSIONS ON AND TO PER NAME TOLERANCE 3- DIMENSIONAL LIMITS APPLY AFTER PLATING SCALE: NTS WEIGHT: N/A SHEET 1 OF 4
THIS DOCUMENT SUPPLIES THE CONSTRUCTION AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR SPECIFICATIONS WITHOUT THE WRITTEN AUTHORITY OF DART AEROSPACE LTD.	

